

Date: Wednesday, 3/14/2007 3:31:11 PM
User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: EXTRUSION "I" BEAM WEB 4"
Job Number	: 31223		
Estimate Number	: 10155		
P.O. Number	: <i>N/A</i>	Part Number	: D25003100
This Issue	: 3/14/2007 S.O. No. : <i>N/A</i>	Drawing Number	: D2500 REV F1
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: 3/14/2007 Type : PURCHASED PARTS	Drawing Revision	: F1
Previous Run	: 25751	Material	: <i>N/A</i>
Written By	: <i>[Signature]</i>	Due Date	: 4/6/2007
Checked & Approved By	: <i>[Signature]</i>	Qty:	<i>167</i> <i>cd</i>
Comment	: Est: E 02.09.10 Added DSK 066 KJ	Um:	90 Each

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 PG PURCHASING



Comment: PURCHASING

- Issue P/O: *3318*
- a) Extrude as per Dwg D2500
 - b) Material: 6061-T6 (QQ-A-200/8)
 - c) Minimum yield tensile strength = 35 ksi
 - d) Minimum ultimate tensile strength = 38 ksi
 - e) Minimum elongation = 10%
 - f) Order at 100" long
 - g) Caradon Indalex Tool # MS-18867
 - h) To be packed per DSK 066
 - i) Pull test to ASTM standard B221 required.
 - j) Material certification is required

C207103115

167

2.0 D25003100P Ext'n - "I" Beam Web 4"



Comment: Qty.: 1.0000 Each(s)/Unit Total: 90.0000 Each(s)
EXTRUSION "I" BEAM WEB 4"

3.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1
Receive & Inspect For Transit Damage
Ensure material certification is attached

[Signature] *07/04/05* *(115)*

4.0 QC6 DIMENSIONAL CHECK



Comment: DIMENSIONAL CHECK
Inspect dimensions per Dwg D2500
Check Pull test per Dwg D2500 for compliance page attached.

0705.14

115

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ Date: 07/05/23
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 3/14/2007 3:31:12 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: EXTRUSION 'I' BEAM WEB 4"

Job Number: 31223

Part Number: D25003100

Job Number:



Seq. #:

Machine Or Operation:

Description :

Check hardness with Webster tester

5.0

PACKAGING 1

PACKAGING RESOURCE #1



115

Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: LG

JD 7-5-23

6.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

LD 071

Job Completion



U 07.05.23

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN <i>DW</i>	DRAWN BY <i>DW</i>	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	
CHECKED <i>KE</i>	APPROVED <i>DW</i>	DRAWING NO. D2500	REV. F SHEET 1 OF 2
DATE 97:09:29		TITLE EXTRUSION	SCALE NTS
A	96:03:19	NEW ISSUE	
B	96:03:24	CHANGE INTERNAL WEB	
C	96:04:26	ADD D2500-3 WEB	
D	96:10:07	ADD MATERIAL PROPERTIES	
E	96:10:24	CHANGE MATERIAL TEMPER	
F	97:09:29	CHANGE MAT. TO 6061-T6	
F1	01.04.17	ADD NOTES 4 & 5 # UP	

RELEASED
47/10/06 DS

1. MATERIAL: 6061-T6 (QQ-A-200/8)

MINIMUM TENSILE YIELD STRENGTH = 35 ksi
MINIMUM ULTIMATE TENSILE STRENGTH = 38 ksi
MINIMUM ELONGATION = 8 %

A SAMPLE FROM EACH BATCH WILL BE PULL TESTED TO ASTM STANDARD B221 BY AN APPROVED TESTING FACILITY TO ENSURE THAT THE BATCH MEETS THE ABOVE MINIMUM MECHANICAL PROPERTIES.

2. BREAK ALL SHARP CORNERS 0.010 MAX

3. TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.

4. FOR D2500-1, PART NUMBER IS D2500-1-XXX WHERE XXX IS CUT LENGTH IN INCHES (EG. D2500-1-190 IS 190" LONG)
D2500-1 EXTRUSION MANUFACTURED FROM: a) BON L DIE # 897105 → PREFERRED
b) CARBON MIDWEST DIE # PAH-28030
c) CARBON MTL DIE # MH-18868

5. FOR D2500-3, PART NUMBER IS D2500-3-XXX WHERE XXX IS CUT LENGTH IN INCHES (EG. D2500-3-100 IS 100" LONG)
D2500-3 EXTRUSION MANUFACTURED FROM CARBON MIDWEST DIE # MS-18867

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ENGINEERING

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SUBJECT TO AMENDMENT
WITHOUT NOTICE

WORK ORDER

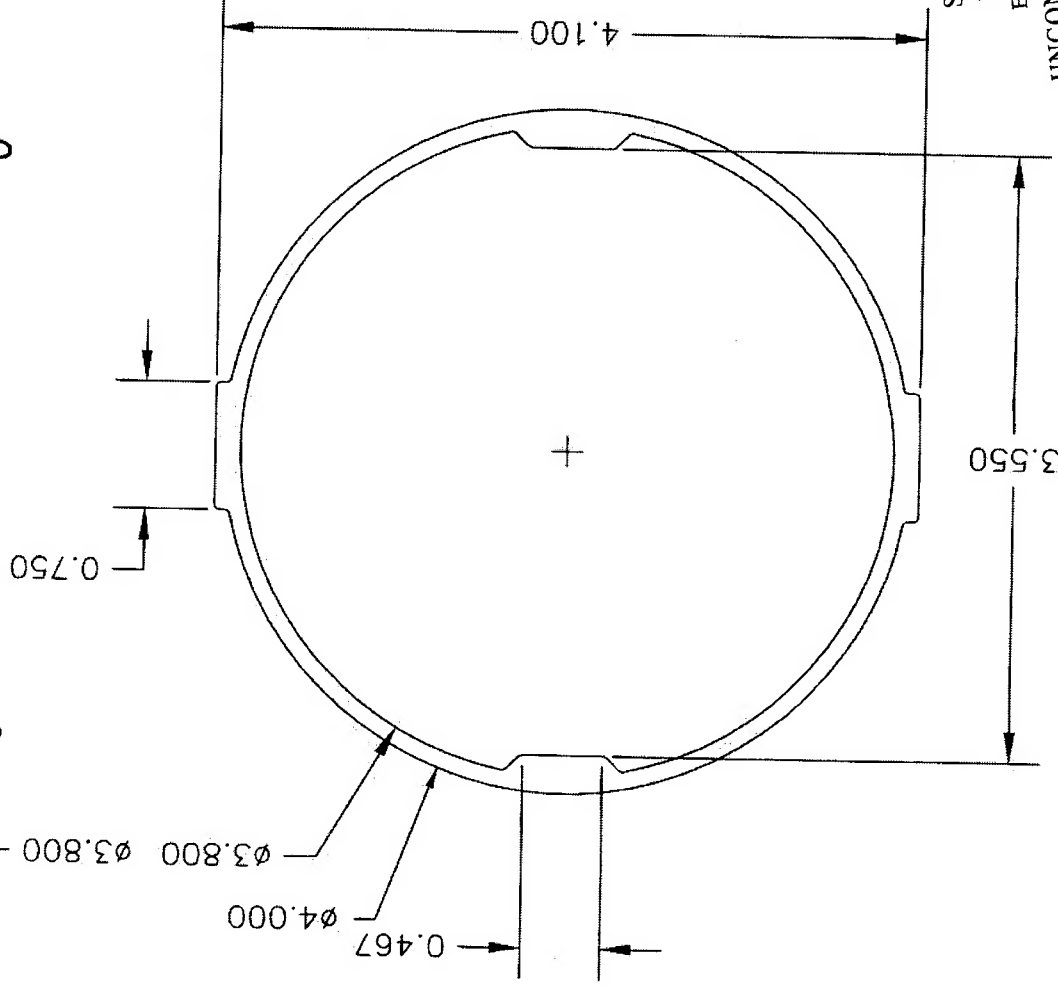
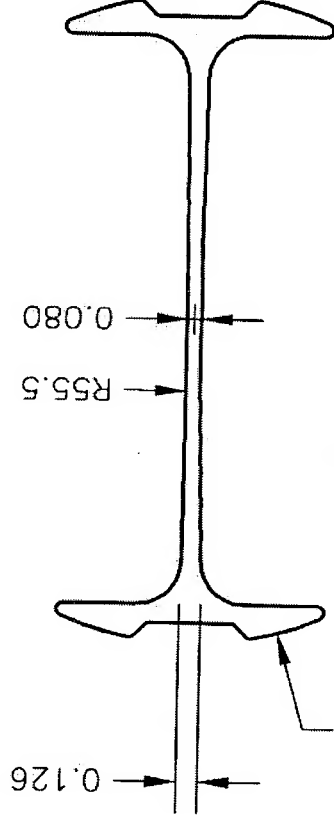
NO. 31223



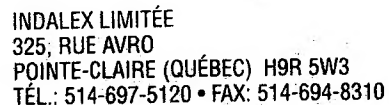
DESIGN <i>MA</i>	DRAWN BY <i>MA</i>	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	
CHECKED <i>KE</i>	APPROVED <i>MA</i>	DRAWING NO. D2500	REV. F SHEET 2 OF 2
DATE 97:09:29	TITLE EXTRUSION		SCALE 1:1

RELEASED
97/10/06 DS

D2500-3



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PROFILÉS D'ALUMINIUM - ANODISATION - FABRICATION - PEINTURE
ALUMINUM EXTRUSIONS - ANODIZING - FABRICATION - PAINTING

VOBRE NOME E DE COM. E
CAB. DE B. NO

7032126

EXPÉDIÉ / SHIP TO

INDICATIONS SPÉCIALES
SPECIAL INSTRUCTIONS

MÊME - SAME

K6A1K7

CUSTOMER P.S.T. : *6122-5207

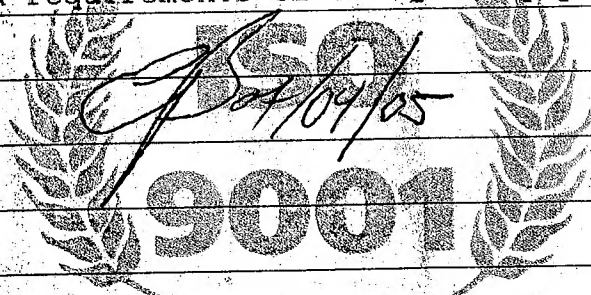
INDALEX G.S.T. REG NO: R136834041

Required Date:

N° DU CLIENT CUST. NO.		TPS. G.S.T.	TAXE DE VENTE PROV. PROV. SALES TAX	N° DE COMM. DU CLIENT CUST. ORDER NO.	DATE DE COMMANDE ORDER DATE	NOTRE DATE DE COMM. OUR ORDER DATE	CONDITIONS TERMS
201355		XXXXXX		3318	7/03/19	7/03/19	
VENDEUR SALESMAN	EXPÉDIÉ PAR SHIP VIA	NOTRE CAMION OUR TRUCK	PAYÉ PPD.	PERC. COL.	C.A.D. C.O.D.	F.A.B. F.O.B.	EN BALLOTS BUNDLED AND TAPED
51			<input checked="" type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>
				NOTRE USINE OUR PLANT		CARTONNÉ & INTERCALE CARTONED & INTERLEAVED	
				<input type="checkbox"/>		<input type="checkbox"/>	

[illegible]

We hereby certify that the material supplied meets the chemical properties as published by the Aluminum Association, and requirements of our Quality procedures



L. G. Cross